

Work Order ID 72587-2

Tuesday, August 02, 2011 2:38:26 PM



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Item ID: D2940-1

Revision ID: ~~0/R~~

Item Name: Support

Start Date: 8/2/2011 Start Qty: 15.00

Required Date: 8/2/2011 Req'd Qty: 15.00

Reference: ECN11-614 *fework*

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2940

Rev B *ECN 11-614*

150



SprayPaint

SprayPaint

0.00

Spray Painting

Memo

0.00

PULL FROM STOCK:
15 X D2940-1 B70737

FOR THE ENTIRE INNER CONCAVE SURFACE:
~ ABRASE SURFACE WITH 400-GRIT SANDPAPER. REMOVE RESIDUE
WITH MEK
(OR EQUIVALENT). APPLY 0.03" TO 0.05" THICK LAYER OF 3M
SCOTCH-WELD 2216 BfA
ADHESIVE TO MATING SURFACE OF SUPPORT. ALLOW TO CURE FOR
24 HOURS.

160



QC

Quality Control

QC 14- Inspect Spray Paint

0.00

Memo

0.00

11 08 15 *(Signature)*

11-08-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72587

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Item ID: D2940-1

Revision ID: U/R

Item Name: Support

Start Date: 8/2/2011 Start Qty: 15.00

Required Date: 8/2/2011 Req'd Qty: 15.00

Reference: ECN11-614

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

170

Identify as per dwg & Stock Location: *X tube*

0.00



Packaging

Memo

0.00

Packaging

re-identify using new h/n

RT 11-08-16 (9)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/18

11-08-16 (9)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 72587

Parent Item: D2940-1

Parent Item Name: Support



Start Date: 8/2/2011


Required Date: 8/2/2011

Start Qty: 15.00

Required Qty: 15.00

Comments:

IPP C 02.11.26 Reformat: Added P/O KJ
IPP Rev:D Added priming as per Rev B 07-04-30 JLM
IPP E 08.03.19 Re-format Ec verified by DD
IPP Rev:F 08-10-22 add qc14 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2940-1  Support		Manufactured	No				Each	0.0000		15			

15 x 70737 h

W/O:		WORK ORDER CHANGES					
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List Lots

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Criteria : Item ID: d2940-1 All Locations All Warehouses All Quantity

Item ID	Warehouse ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt	Type Code	Comments
Item Name	Location ID				Lot Code		
D2940-1	Main Warehouse	70737	7/6/2011	15.0000	QC21		
Support	LG						
			Total:	15.0000			

72587

W

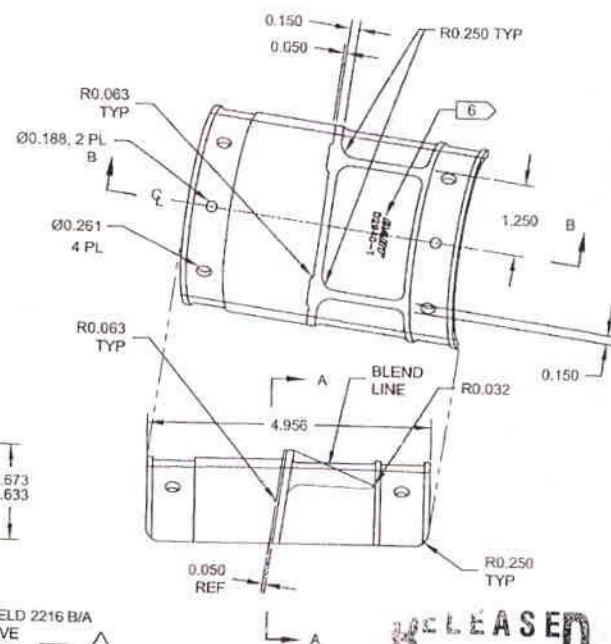
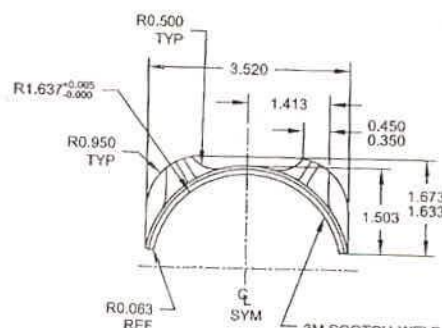
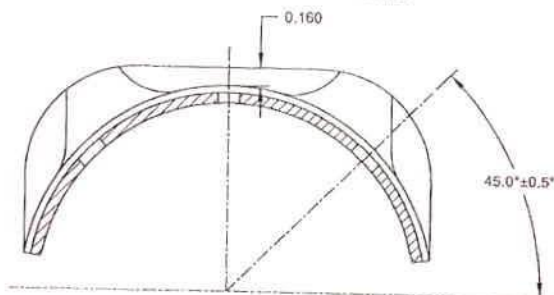
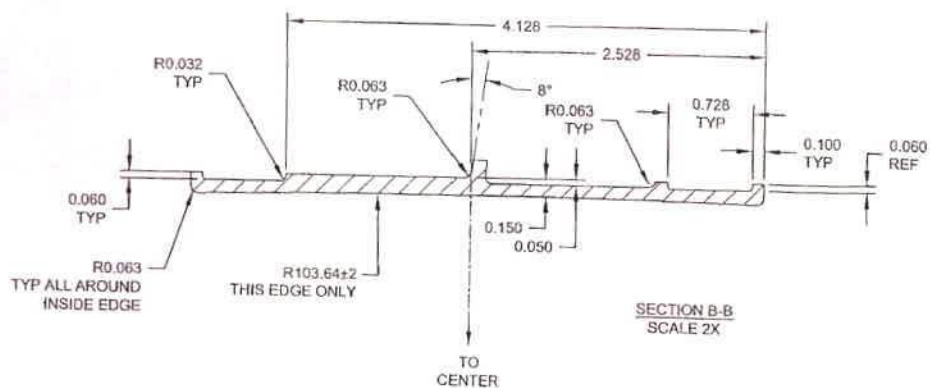
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NOTES:

1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION
MIN UTS = 170 KSI (38 HRC)
(REF DART SPEC. D6104)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 016 (REF X.XXX = ±0.010) UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP, PER DART QSI 044 6.3.

7) WEIGHT: 0.92 lb

8) FOR THE ENTIRE INNER CONCAVE SURFACE: ABRASE SURFACE WITH 400-GRIT SANDPAPER, REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY 0.03\"/>

D2940-1 SUPPORT

REV.	DESCRIPTION	CP	DATE
C	RMV FINISH, ADD 3M 2216, ADD H925 MATL OPTION	CP	11.07.15
B	UPDATE PER NCR-642, PRIME INSIDE	PH	07.03.13
A	NEW ISSUE	CP	01.01.10
DESIGN		BY	
DRAWN		DATE	
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.07.15		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D2940
TITLE Ø3.250 SUPPORT
SCALE NTS
REV. C SHEET 1 OF 1

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RELEASED
2011-07-28

W/O:		WORK ORDER CHANGES					
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